



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3052-1

Job Sheet 181144



Part No: D3052-1

Job Qty: ~~200~~ *3ea*

DAS
21
9-89

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REY B IPP: A 02.01.28 New Issue NG IPP: B Rev.B dwg 07-09-25 DD verified by EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		8/3/18	0.00	0.00	Start Up Machining-1		<i>Marie 8/3/18</i>
100	Bandsaw	2 pcs		8/3/18	0.00	4.43	Bandsaw1		<i>"</i>
110	CNC Vertical Machining	2 pcs		8/3/18	0.64	4.44	HAAS1-3		<i>"</i>
120	QC	2 pcs		8/3/18	0.00	0.00	QC2 Machining-1		<i>"</i>
130	QC	2 pcs		8/3/18	0.00	0.00	QC8 Machining-1		<i>Marie 2018-08-03</i>
140	HandFinish	2 pcs		8/3/18	0.00	0.08	HandFinish1		<i>SA 18-08-07</i>
150	Powdercoat	2 pcs		8/3/18	0.00	0.49	Powdercoat1		<i>SA 18-08-07</i>
160	QC	2 pcs		8/3/18	0.00	0.00	QC3		<i>AUG 1 3 2018</i>
170	Packaging	2 pcs		8/3/18	0.00	0.00	Packaging3-1		<i>AUG 1 6 2018</i>
180	QC21-SA	2 Ea		8/3/18	0.00	0.00	QC21		<i>DAS 21 9-89</i>

Part Op 100 - Cut blanks: 5.600" long *****1 BLANK MAKES 2 PARTS*****

Descriptions: 110 - Machine as per folio FA184

150 - *****mask slot as per dwg*****

START 11:15am 5688892
Comp 3205
FIN 11:45am

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	.5000 ft (.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	1	56	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	0.250Inches ± 0.010	0.260 0.240	Radius	
2	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
3	Mounting Lug	0.875Inches ± 0.010	0.885 0.865		
4	Mounting Lug	1.525Inches ± 0.010	1.535 1.515		
5	Mounting Lug	2.575Inches ± 0.010	2.585		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : 18/08/01		Step #: 100		QTY Effective :		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
The bottom part is under .005. The tolerance as shown on drawing is .115 $\pm$ 0.010 																									
				Completed By 18/08/01		Lead hand / Supervisor Approval Verification 18/08/01																			
				QC / QA Coordinator Approval																					
Root Cause				FAULT CATEGORY																					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐																		
Design	☒	Operator	☐	Bending	☐	Set-up	☐																		
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐																		
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐																		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐																		
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐																		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐																		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐																		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐																		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐																		
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																					
Misidentified	☐	Past Due	☐																						

			2.565	
6	Mounting Lug	0.500Inches ± 0.010	0.510 0.490	Radius
7	Mounting Lug	3.250Inches ± 0.010	3.260 3.240	
8	Mounting Lug	0.257Inches $+ 0.006$ $- 0.001$	0.263 0.256	Diameter
9	Mounting Lug	0.375Inches ± 0.010	0.385 0.365	
10	Mounting Lug	1.875Inches ± 0.010	1.885 1.865	
11	Mounting Lug	3.375Inches ± 0.010	3.385 3.365	
12	Mounting Lug	3.750Inches ± 0.010	3.760 3.740	
13	Mounting Lug	0.115Inches ± 0.010	0.125 0.105	
14	Mounting Lug	3.075Inches ± 0.010	3.085 3.065	
15	Mounting Lug	0.060Inches ± 0.030	0.090 0.030	Radius
16	Mounting Lug	0.500Inches ± 0.010	0.510 0.490	
17	Mounting Lug	0.250Inches ± 0.010	0.260 0.240	
18	Mounting Lug	0.770Inches ± 0.010	0.780 0.760	
19	Mounting Lug	1.000Inches ± 0.010	1.010 0.990	
20	Mounting Lug	3.750Inches ± 0.010	3.760 3.740	
21	Mounting Lug	0.386Inches $+ 0.006$ $- 0.001$	0.392 0.385	Diameter

Plex 7/23/18 9:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



QA Clo

Work

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/18

Date :



Container No: S098497



Part: D3052-1

Job No: 181144

Serial No/Batch: S098497

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DATE

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Contamination	☐	Out of Sequence	☐	Part Moved	☐
Countersink	☐	Off-set	☐	Drawing	☐
Cut Too Short	☐	Mislabeled	☐	Finish	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER : _____